

Date: Wednesday, 1/31/2007 2:18:48 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE
Job Number : 30551
Estimate Number : 10298
P.O. Number : N/A Part Number : D25773
This Issue : 1/31/2007 S.O. No. : N/A Drawing Number : D2577 REV E
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB Drawing Revision : E
Previous Run : 29960 Material : N/A
Due Date : 2/12/2007 Qty: 50 Um: Each
Written By :
Checked & Approved By :
Comment : Est. F 02.09.24 Re-format; Incorporated D2577-101/-13 K
J/RF
Est. C 06.07.21 waterjet EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S16GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 1 sf(s)/Unit Total : 46 sf(s)
1010/1025/A21/6aA SHEET 0.063 thick

Batch: M103846(50) M101926 CU

SAD 07/03/07

50

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut D2577-101 as per Dwg D2577
Dwg Rev: E
Prog Rev: E

2-Deburr if necessary

SAD 07/04/07

50 PTU

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/04/07

51

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

204-03

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr


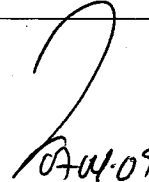

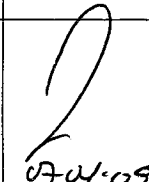

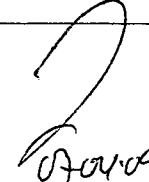

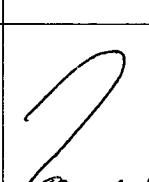
SAD 07-04-07

49

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/09	2.0	waterjet miss cut a hole 1st part		Scrap and destroy	SAN 07/04/09			
07/04/09	2.0	1 part scrap. hole was not cut out completely. very bad.		Scrap & destroy	SB 07/04/09			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:18:48 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 30551

Part Number: D25773

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake as per Dwg D2577 using DT8155 and DT8179

2-Identify as D2577-3

mf

07-04-09

(49)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/10

(49)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty Description

Batch

A/R 7560 Hardcoat Rod

M103794

M103551

FC 07/04/18

(49)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/04/18

(49)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M101601

JS

07-04-19

(49)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF

07/04/19

(49)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: EP-15

JS

07-04-19

(49)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

LP 07/04/20

(49)

Job Completion



U JF-M-W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
00 09 22

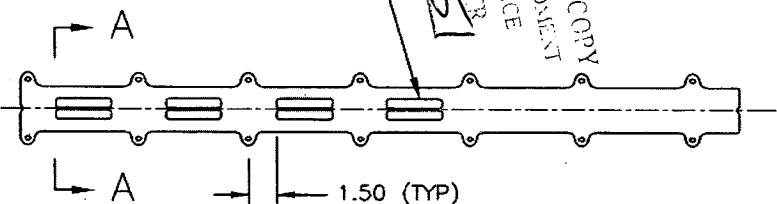
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CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	00.09.22	REVISIONS
00.09.22	00.09.22	00.09.22
A	96.09.16	NEW ISSUE
B	96.12.04	ADD HARDCOAT WELDS
C	97.05.30	CHANGE HOLES TO OBROUNDS
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



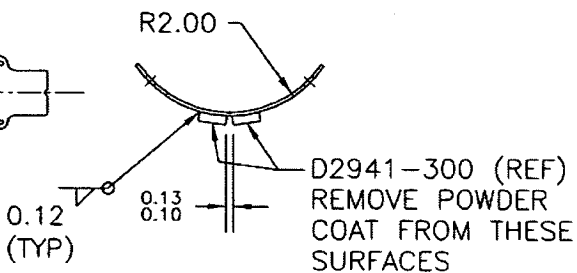
D2577-1 & D2577-3 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2941-300
SHWAYDER WEAPADS
(8 PLACES)



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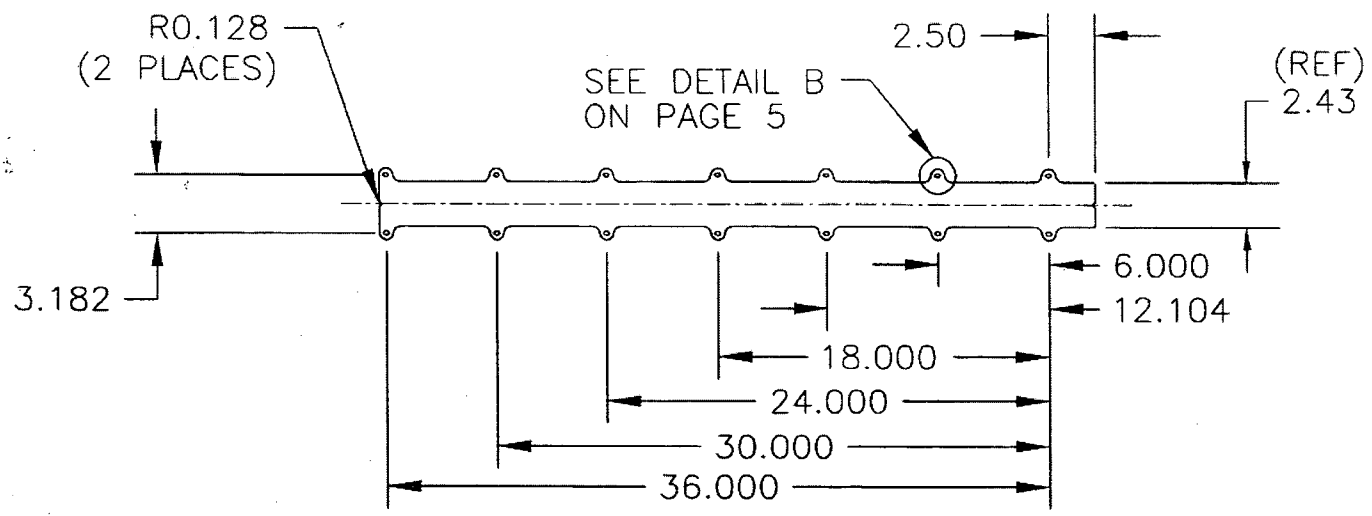
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SCALE 1:5



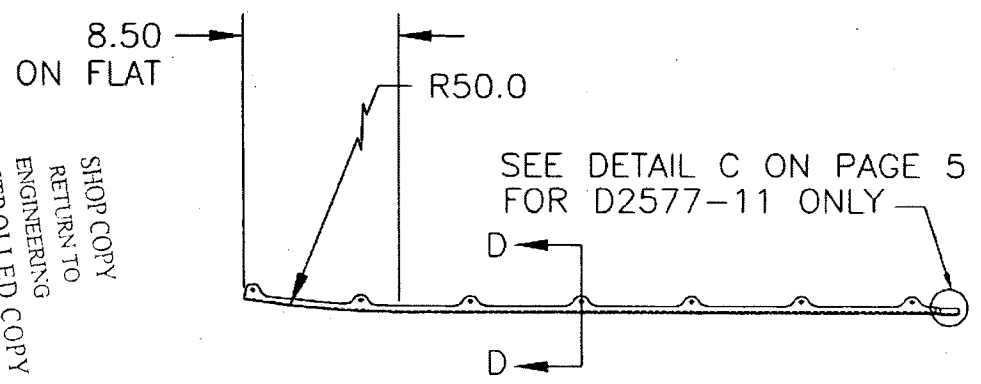
D2577-21 & D2577-23 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DRAWING NO.	REV. E
	CP	D2577	
CHECKED	APPROVED	TITLE	SHEET 2 OF 5
00.09.22		WEARSHOE	SCALE 1:10



D2577-101 FLAT PATTERN
BREAK ALL SHARP CORNERS 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND
MAKE FROM D2577-101
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
00.09.26 #

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NO. 30551

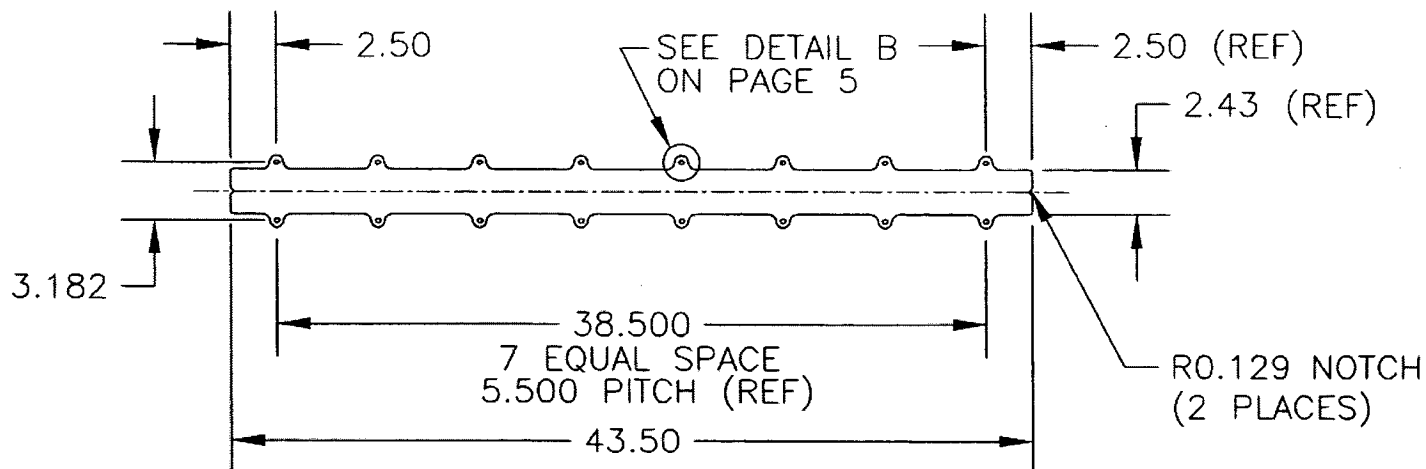
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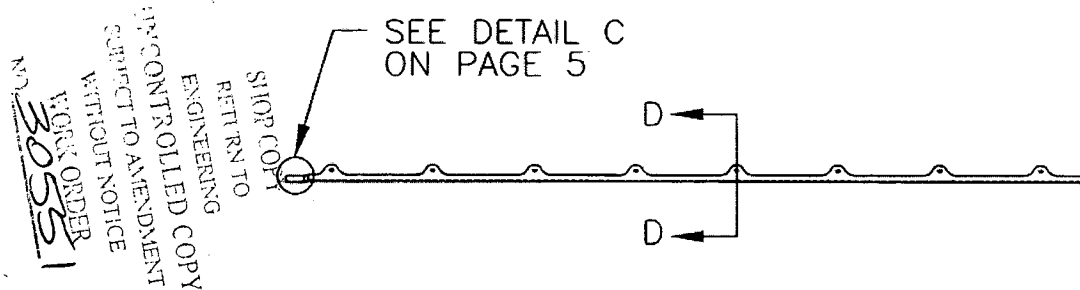
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. E
00.09.22	D2577	SHEET 3 OF 5
	TITLE	SCALE
	WEARSHOE	1:10

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00.09.26

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

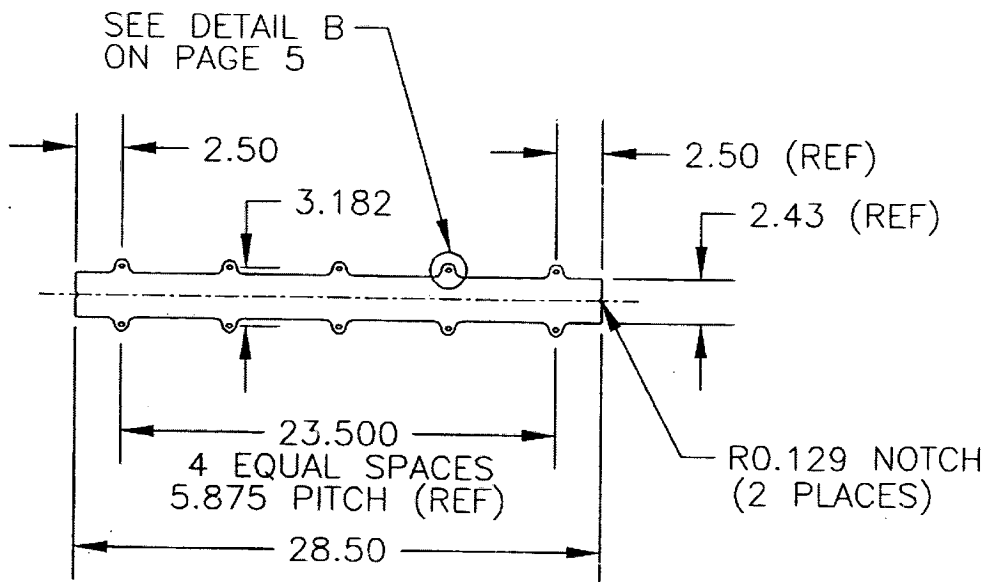
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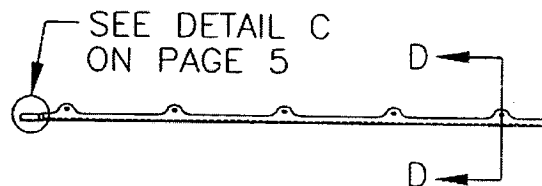
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CHECKED	APPROVED	DRAWING NO. D2577
DATE 00.09.22	TITLE WEARSHOE	REV. E SHEET 4 OF 5
	SCALE 1:10	

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00 09 26

D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

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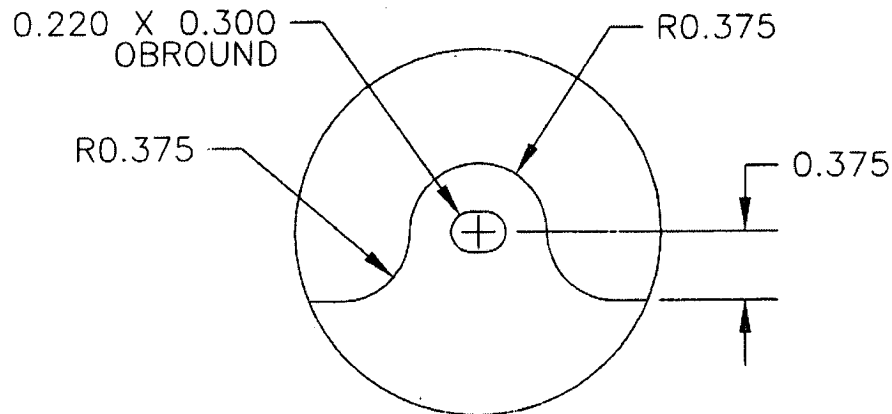
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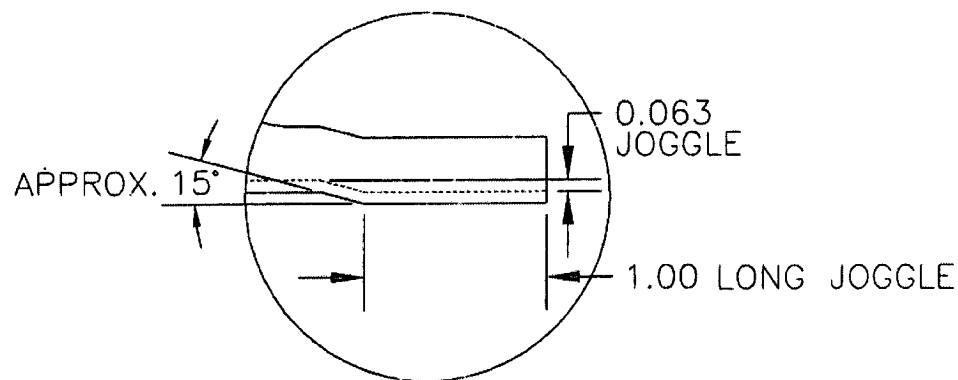
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DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

RELEASED
00.09.26

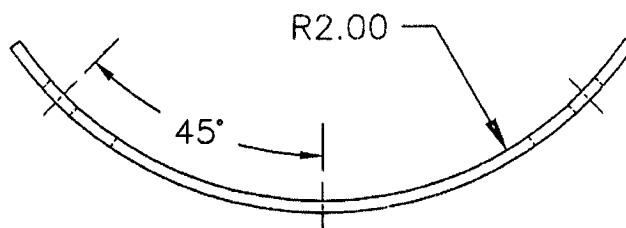
DETAIL B (SCALE 1:1)



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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DART AEROSPACE LTD		Work Order: 30551
Description:		Part Number: D25773
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	3.182	+/- 0.010	3.186	✓		Vern	
B	36.000	+/- 0.010	36.000	✓		M-T	
C	30.000	+/- 0.010	30.000	✓		M-T	
D	24.000	+/- 0.010	25.000	✓		M-T	
E	18.000	+/- 0.010	18.000	✓		M-T	
F	12.104	+/- 0.010	12.109	✓		Vern	
G	6.000	+/- 0.010	6.001	✓		Vern	
H	2.43	+/- 0.030	2.44	✓		Vern	
I	2.50	+/- 0.030	2.50	✓		Vertical Vern	
J	0.220	+/- 0.010	0.217	✓		Vern	
K	0.300	+/- 0.010	0.300	✓		Vern	
L	0.063	+/- 0.010	0.060	✓		Vern	
M							
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by: SAN	Audited by: Sn	Prototype Approval:	N/A
Date: 07/04/07	Date: 07/04/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	